

Work Order ID 94701***94701***

Page 1

December-19-12 3:06:44 PM

Item ID: D3913-3

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Rib

Stop

NS2

Start Date: 12/24/12 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/11/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

*LL*Date: 12/20/12 Tooling:

Date:

Run

Start

NR1

QC:

Date: _____ SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3913	B								
100 *100* Large Fab	Memo 1- Cut tube as per dwg D3913 2- remove identification marks and deburr	0.00							<u>6</u> <u>Q1/2/12/21</u>
110 *110* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00							<u>6x</u> <u>Q1/2/12/21</u>
120 *120* Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00							<u>6x</u> <u>Q1/2/12/21</u>

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Part No. _____ NCR No. _____										
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other						
				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled						

Work Order ID 94701

94701

Page 2

December-19-12 3:06:44 PM

Item ID: D3913-3

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Rib

Stop

NS2

Start Date: 12/24/12 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/11/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Quality Control

13/01/22

13/01/22

NCR: Yes / No

DQA: Date: *

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Picklist Print

December-19-12 3:06:43 PM

Page 1

Work Order ID: 94701

Parent Item: D3913-3

Parent Item Name: Rib

Start Date: 12/24/12

Required Date: 1/11/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
DD verf:EC

IPP Rev:B 11.02.04 chg qc5 to 6

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049 304 SQ Tube .75x.75x.049W		Purchased	No			100	f	905.1312	8	50.526316			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT017	2.0156214	
121898	2.0156214	
WA006	903.1155859	
122201	0.1626	
122425	39.0000000	
122666	0.7293	
122710	20.5	
123219	289.5	50.53
123484	553.223686	

6 01/13/01/21

NCR: Yes / No

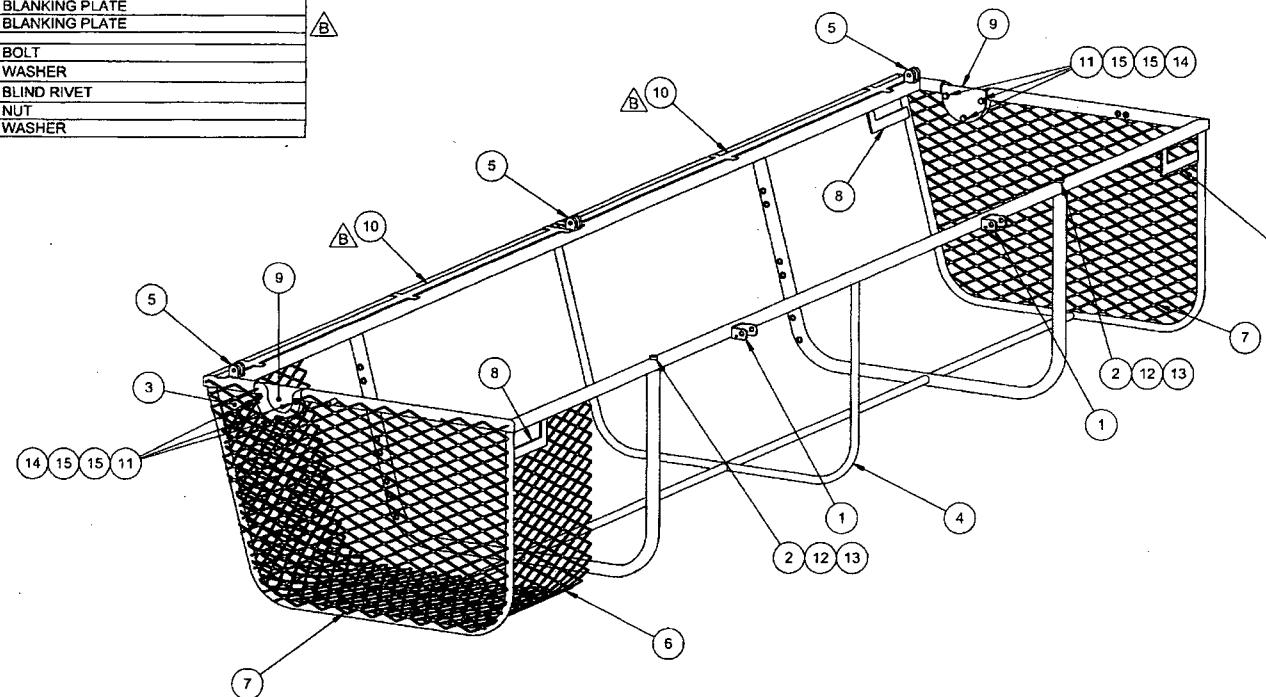
DQA: Date: 1

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
			Bending	Bend	Grain	Ovalized	Pressure/Forced				
Centre Not Concentric to O/S			BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure					
Cracks			Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld					
Crushed/Crimped.			Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled					
Cuffs			Contamination	Maintenance	Part Moved						
Heat Treat			Countersink	Mislabeled	Positioned Wrong						
Inspection Strip in Tube			Cut Too Short	Misread	Power Loss/Surge						
Ripples in Bend			Drill Holes	Offset							
Torque Waves in Extrusion			Drawing	Out of Calibration							
Turning Sequence			Finish	Out of Sequence							
Wave/Twist in Tube			Folio	Outside Dimensions							

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-1	BLANKING PLATE
11	6	AN3-10A	BOLT
12	2	AN960JD8	WASHER
13	2	MS20600AD4W3	BLIND RIVET
14	6	MS21042L3	NUT
15	12	NAS1149F0332P	WASHER

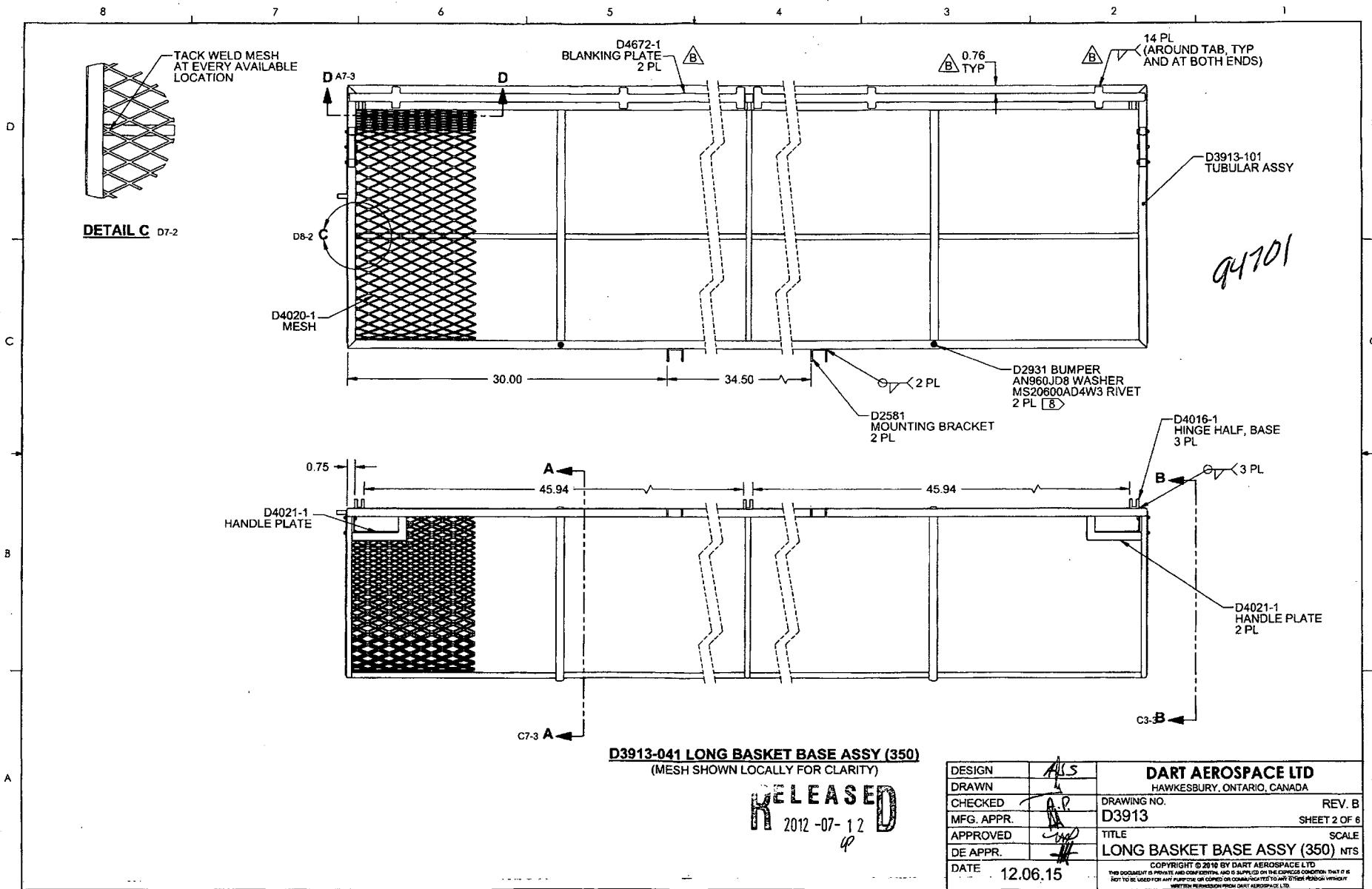


D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:
 1) MATERIAL: N/A
 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: NONE
 7) WEIGHT: 43.9 lbs APPROX
 8) INSTALL AFTER FINISH
 9) MASK HOLES PRIOR TO POWDER COAT
 10) WELD PER DART QSI 004

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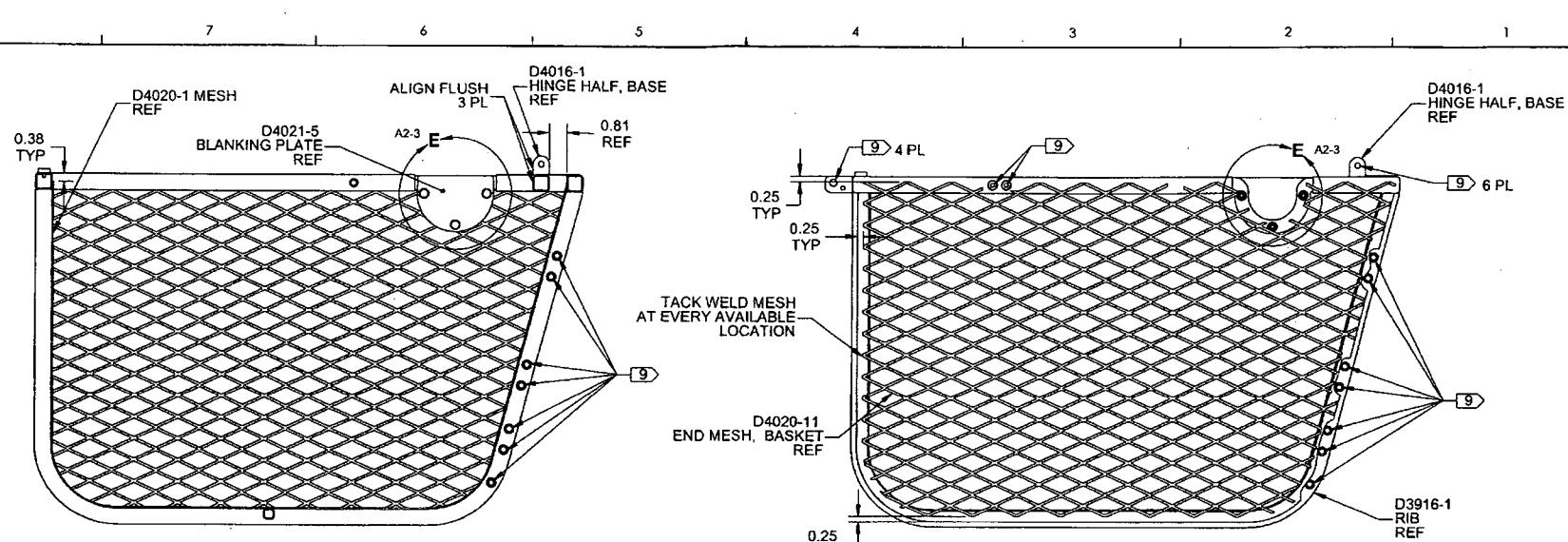
B	ADD D4672-1 (ZN C4-1, C6-1, D2-2, D2-3, & D5-2).	MB	12.06.15
A	REASON: PART2-197.	JPH	10.03.16
REV.	DESCRIPTION		
DESIGN	AS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	IP	DRAWING NO.	REV. B
MFG. APPR.		D3913	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

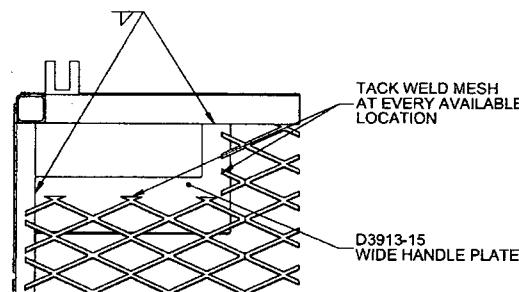
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2012-07-12
10

DESIGN	<i>115</i>	DART AEROSPACE LTD	
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AP</i>	DS3913	SHEET 2 OF 6
APPROVED	<i>115</i>	TITLE	SCALE
DE APPR.	<i>115</i>	LONG BASKET BASE ASSY (350) NTS	
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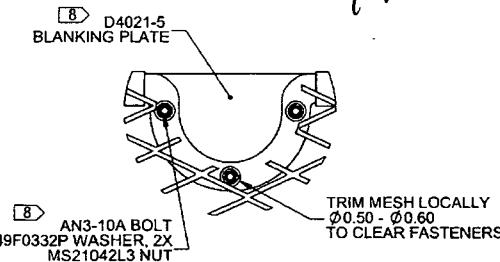


SECTION A-A A5-2

VIEW B-B A2-2



SECTION D-D D6-2
TYPICAL FOR ALL
HANDLE PLATES

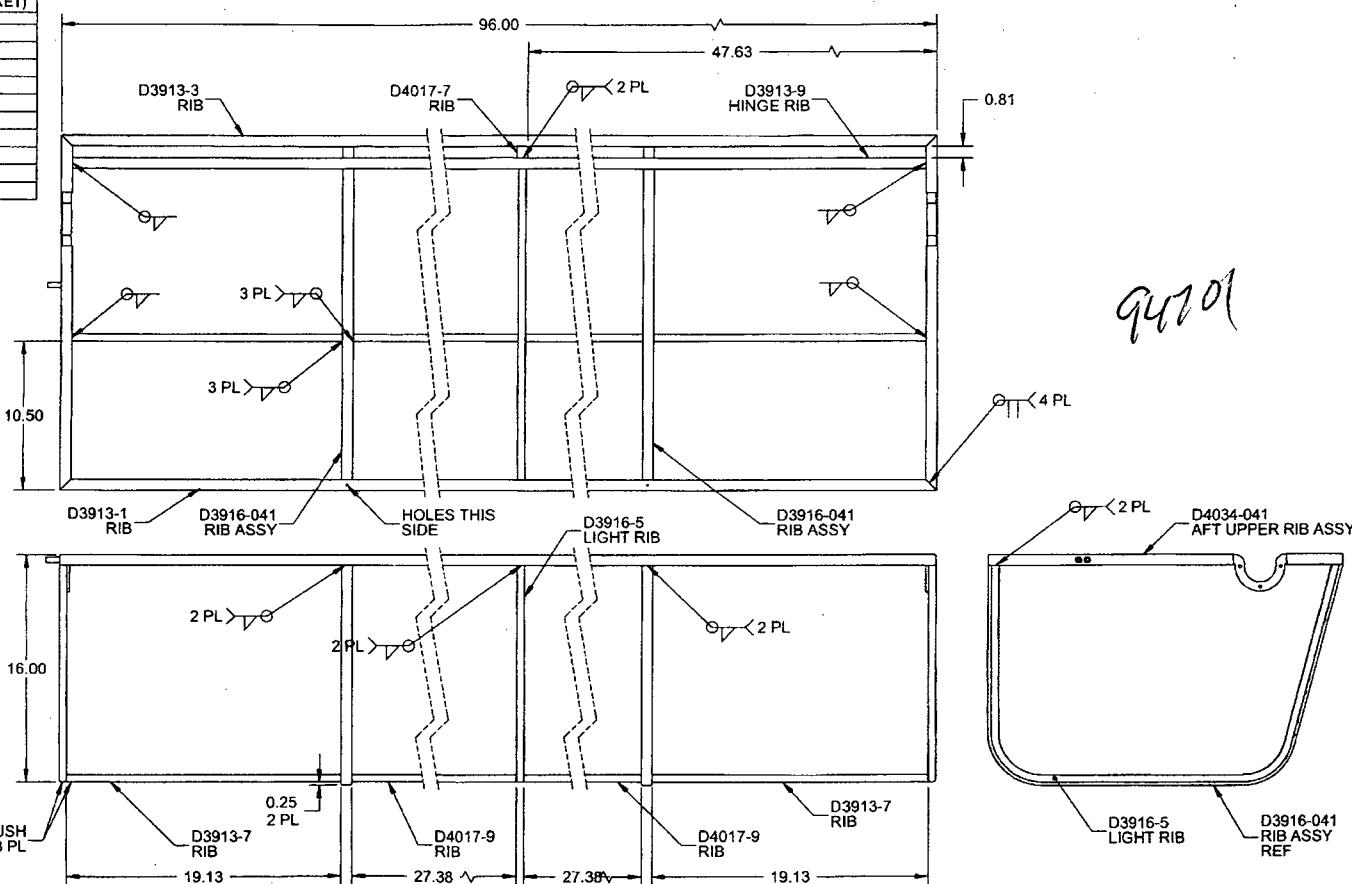


DETAIL E D2-3
D6-3

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2012-07-12
IP

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DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	IP	DRAWING NO.
MFG. APPR.		REV. B
APPROVED	IP	D3913
DE APPR.		SHEET 3 OF 6
DATE	12.06.15	SCALE
		LONG BASKET BASE ASSY (350) NTS
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ITEM	QTY	P/N	DESCRIPTION
	8	X	D3913-101 TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



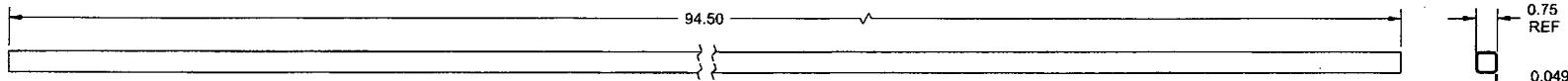
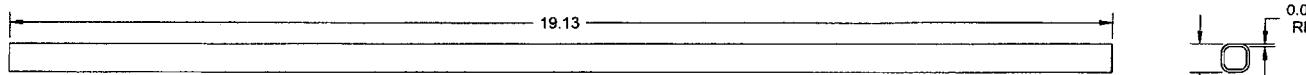
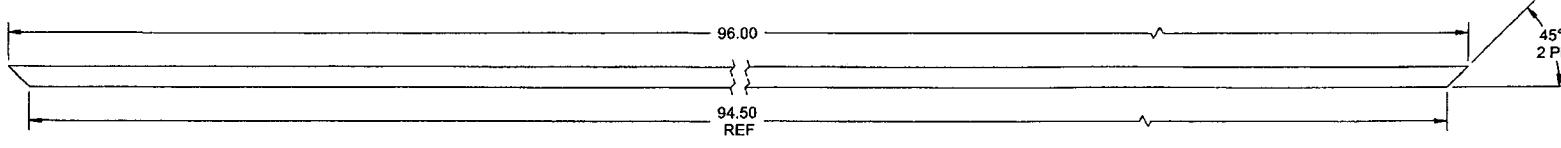
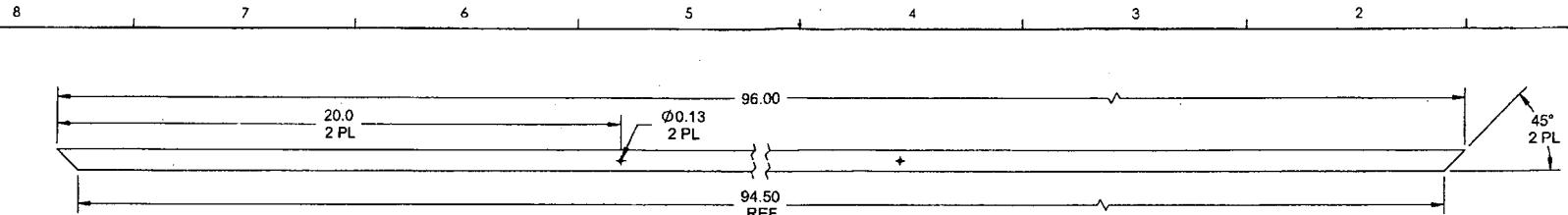
8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 22.53 lbs
 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
 9) WELD PER DART QSI 004

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2012-07-12
9

DESIGN	A/S	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	A.P.	REV. B
MFG. APPR.		D3913
APPROVED		SHEET 4 OF 6
DE APPR.		TITLE
DATE	12.06.15	SCALE
		LONG BASKET BASE ASSY (350) NTS

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94101

NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

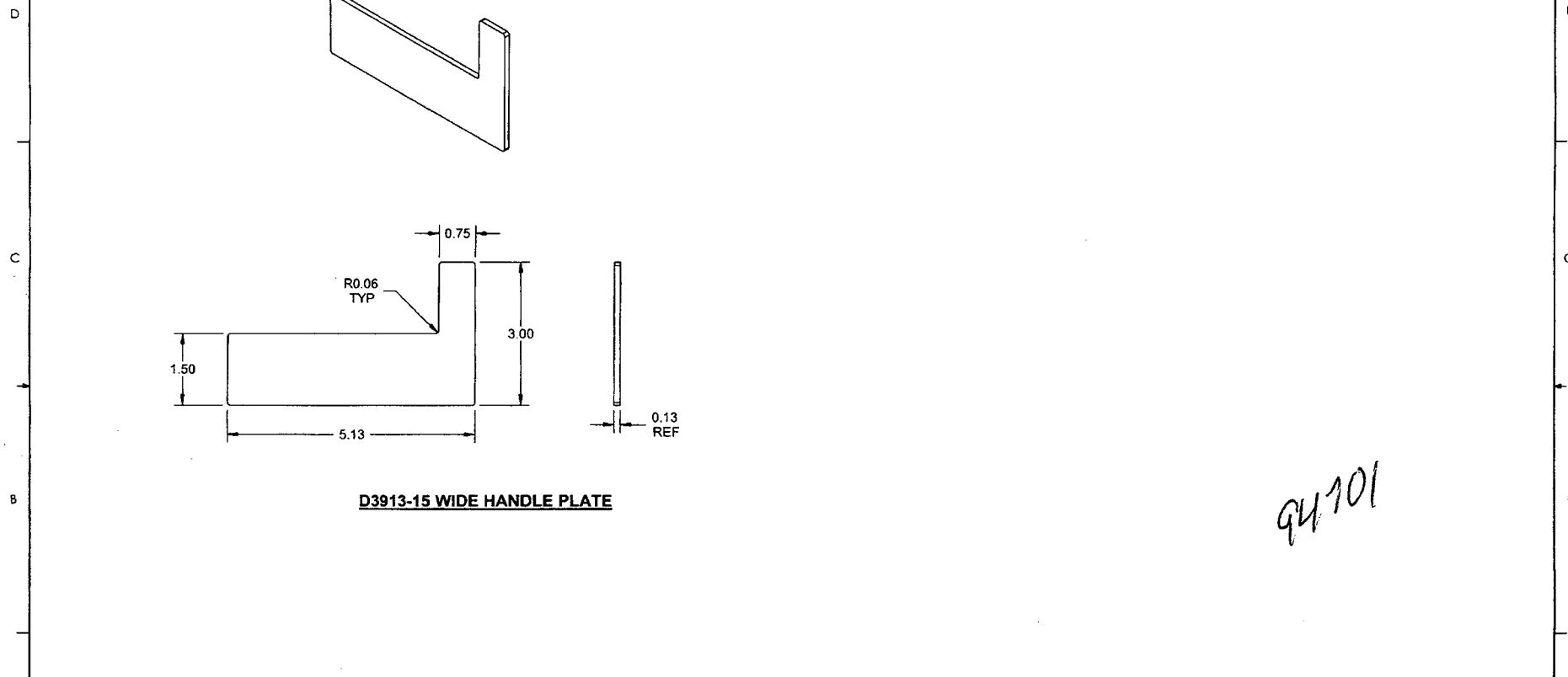
7) WEIGHT: SEE ASSEMBLED WEIGHTS

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2012-07-12
4P

DESIGN	ALS	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	R.P.	REV. B
MFG. APPR.		D3913
APPROVED	J.W.	SHEET 5 OF 6
DE APPR.		TITLE
DATE	12.06.15	SCALE
		LONG BASKET BASE ASSY (350) NTS

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8 7 6 5 4 3 2 1



NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

RELEASED
2012-07-12
P

DESIGN	A.S	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		REV. B
CHECKED	A.V.	DRAWING NO.
MFG. APPR.		D3913
APPROVED		TITLE
DE APPR.		SCALE
DATE	12.06.15	LONG BASKET BASE ASSY (350) NTS

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